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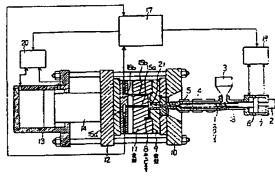
TSURUMAKI MASA;

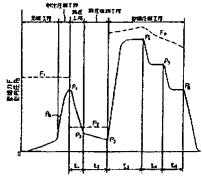
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TITLE

INJECTION MOLDING PROCESS





ABSTRACT :

PURPOSE: To make the photocharacteristic of a molded product to be excellent, removing its residual stress-fracture, warpage and deformation by a method in which the incline of the inner pressure of a mold in the flow direction of a molded product before the process of mold clamping/compressing, is omitted, and the mold clamping/compressing is further precisely multistage-controlled.

CONSTITUTION: To equalize the amount of injected resin of every shot when the inner pressure Pa of a mold (near a gate) obtained by a sensor 16a reaches injecting compressive pressure P_1 (filling pressure in the mold plus compressive pressure) having been preliminarily set, a screw 1 is retreated and the inner pressure is reduced to P_2 from P_1 . After that, the inner pressure Pa of the mold is regulated to P_3 by the fine advance and retreat of the screw correspondingly to the change of the inner pressure Pb (the end of resin blow) of the mold obtained by the sensor 16. Its regulation time is controlled with the fine regulation timer t_2 for pressure reducing constant. Then, the process is advanced to the compression caused by mold clamping pressure, and the detected inner pressure P_3 of the mold is compared with preliminarily set values P_4 , P_5 , P_6 , thereby operating the control mechanism 20 for mold clamping, and controlling the mold clamping process by a closed loop.

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